Date:

Wednesday, 3/14/2007 12:25:14 PM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31188

Estimate Number : 11123

P.O. Number

:NIA

This Issue Prsht Rev.

: NC : MIM First Issue

Previous Run

Written By

Checked & Approved By

Comment

: NIA

3/14/2007

: Est Rev: F

S.O. No. : N/A

Type

: LARGE FAB ASSY

Added Finish as per Rev D 05-11-30 JLM

Material **Due Date**

: N/A : 3/30/2007

D2460

: N/A

: D

D2460 REV D

: STEP WELDMENT

Qty:

4 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2244116

Step Extrusion



Comment: Qty.: Pick:

0.5000 Each(s)/Unit Total:

Description

Step Extrusion

2.0000 Each(s)

4.0000 Each(s)

23404=1 used scrap

Qty

Part #

D2244

Comment: Qty.: 1.0000 Each(s)/Unit

> Pick: Qty

Part Number

D2338-1

Description

Total:

End cap

Batch No. 33/209 = 2*

3.0

1 D23382

End Cap



Comment: Qty.:

Pick: Qty

D2338-2

Part Number

1.0000 Each(s)/Unit

Description End cap

Total:

Batch No.

4.0000 Each(s)

3/6855 €2

3 31210 =2 *



£.01.03.20

4.0

D2459

Pick: Qty

1

1

204 Step Lug

D2459

Comment: Qty.:

1.0000 Each(s)/Unit

Part Number

Total:

4.0000 Each(s)

Description Lug

32/8/2 = 2

Form: mrocess

Dart Aerospace Ltd

| W/O: | | | WORK OF | RDER CHAN | GES | | | | | |
|---------|------|--------|-----------------|-----------|------|--------|-------|--------------------|-------------------------------------|--------------------------|
| DATE | STEP | PROC | EDURE CHANGE | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | : | | | | | | - Angeliani, and a | | |
| | | | | | | | | | | |
| | | | · | *** | - Na | | | | and the | 1 |
| Part No |): | PAR #: | Fault Category: | | | R: Yes | No DQ | A: | Date: | |

| | | | | | | | : | - 4.2 | QA: N/C | Closed: | _ Date: _ | |
|------|------|-------------------|--------------|---|-------|------------|----------------------|-----------|----------------|----------------------|-----------------------|--------------------------|
| NCR: | | | WC | ORK OF | DER | NON-CO | NFOR | MANCE | (NCR) | | | • . |
| | | Description of NC | | | | rective Ac | tion* _* s | Section B | | Verification | Approval | Annroval |
| DATE | STEP | Section A | | Initial Chief Eng⊀ | seft. | Action D | escription of Eng | ູ້ນ | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector |
| | | koz | ⁵ | | | | | 4 | | ®Na act act ₹2 | | |
| | | , | | | | | | | | | | |
| d'a | • | | | | | | | _ | | | | |
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NOTE: Date & initial all entries

| Date: | Wednesday, 3/ | 14/2007 12:25:15 PM | • | / | |
|-----------|--------------------------|---|--|--|------------|
| User: | Kim Johnston | | Process Sheet | | |
| Custo | omer: CU-DAR00 | 01 Dart Helicopters Services | Drawing Nam | me: STEP WELDMENT | |
| | | | ., | | |
| Job Nui | mber: 31188 | | Part Number | per: D2460 | |
| Job Numbe | er: | | | | |
| | | | | | |
| Seq. #: | Machine | Or Operation: | . D | Description : | |
| 5.0 | LARGE FA | B1 | LARGE FABRICATION RESC | SOURCE 1 | |
| | | | | | |
| C | IIII Comment: LARGE | III III III III III IIIII E Fabrication resource | F 1 | 111111111111111111111111111111111111111 | |
| | : | TABRIOATION RECOORCE | | 10 % | |
| | - 1-Cut [| D2244 per Dwg. D2460 | 12.01.03.22 | SEE MB PRIOR WELDING D2338-1/-2 TO D2244-48 | |
| | 0 Mald | Iman Dura DO460 | 1 | D2338-1/-2 TO D2244-48 | 3.8 |
| | | l per Dwg. D2460 Alum rod Batch: <i>M/16</i> | 1 // | | |
| | 7411 | Alum rod Batch: M/O | 02025 1.6 | .07.03.22 | |
| | 3-Debu | | SE | .07.03.22 | |
| 6.0 | QC 1 /5/ 9 | 11 | INSPECT WORK/WING WAL | LK | 1 |
| | | | | | 7 |
| C | omment: INSPE | CT WORK/W ING WALK ins | pocto weld | 407/03/22 (4) | |
| - 7.0 | HAND FINI | | HAND FINISHING RESOURCE | 10.10.110.11 | |
| | | | | | |
| | | | ••• | 1701/1101/1101/1101/1101 | |
| C | | FINISHING RESOURCE #1 cal Conversion Coat as per Q | 9100541 | 07-03-22 | 11 |
| 8.0 | | | POWDER COATING | 07-03-66 | \exists |
| · · | 111 | | • | i leki il diredi dirik deli deli | |
| | | | | | |
| ,C | omment: POWD | | F 4) | | |
| 9.0 | Powder HAND FINI | r Coat White Gloss (Ref: 4.3.5 | b.1) as per QSI 005 4.3 HAND FINISHING RESOURCE | $\frac{a.m}{0.03}$ 22 (4) | <i>"</i> — |
| 3.0 | | | TIAND FINISHING RESCORE | | |
| | | | | | |
| Co | | FINISHING RESOURCE #1 | | | • |
| | Wing W Batch: | Valk per dwg D2460 | | 1 / 1/4 | <i>i</i> . |
| 10.0 | QC3 | 70 7 17 0 | INSPECT POWDER COAT/C | $\frac{2}{3}$ $\frac{1}{3}$ $\frac{3}{26}$ $\frac{9}{3}$ | |
| 10.0 | . []]] | | INOI EOT FOMBER GOMIO | | |
| | | | | | |
| | | t Powder Coat and Wing Wall | | 1/3/27 (4) | |
| 11.0 | PACKAGIN | G 1 Denote de la company de la | PACKAGING RESOURCE #1 | | |
| | | | | | |
| Co | Omment: PACKA | GING RESOURCE #1 | | 1186111 1881111881 11811 . | |
| | ▶ . | and Stock |) () () | | ~ |
| | Location | 11112 | D204-61 | 18-011 /0/3/27/4 | <u>/</u>] |
| _ | | , | / | | / |
| | | | • | | |
| | | | | | - 1 |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | ··· |
|----------|------|---|--|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/03/22 | 6.0 | Sc 5/9 | AS | 07/03/22 | 4 | | \$ 07/03/ |
| 7 | 601 | Chemical Conversion Coat | THE STATE OF THE S | 76302 | 4 | | |
| | 6.2 | Qc3: | FF | 07/03/22 | 4, | | |
| | 6.3 | large Fab. deburr and bevel Beft end for welding / Weld as peso | | | | | |
| | 6.4 | Oc 5/9 | W | 07/03/23 | | | |
| | | All perm. change | | 7-7- | , | | |
| | 1 | penni. Change | | | | | 1 |

| Part No: | PAR #: | Fault Category: | NC | R: Yes No DQA: | D Date: 07/03/18 |
|----------|--------|-----------------|----|-----------------|------------------|
| | | | : | QA: N/C Closed: | Date: |

| NCR: | | · | WORK ORDI | ER NON-CONFORMANO | CE (NCR) | | | |
|------|------|------------------------|----------------------|------------------------------|----------------|------------------------|-----------------------|--------------------------|
| | | STED Description of NC | | Corrective Action Section B | | | Ammanal | Ammanual |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Date:

Wednesday, 3/14/2007 12:25:15 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Part Number: D2460

Job Number: 31188

Seq. #:

Machine Or Operation:

Description:

12.0 ·

Job Number:

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHAN | GES | | | | |
|---------|------|------------------------|----------|-----------|------------|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | * | | | |
| | | | | | | | |
| | | | | | | | _ |
| | | | | | | | |
| Part No | • | PAR #: Fault Category: | NCR: Yes | No DQ | A : | Date: | |
| | | | QA: | N/C Close | d: | _ Date: _ | |

| NCR: | | W | ORK OR | DER NON-CONFORMANC | E (NCR) | | | |
|-------------|------|-------------------|----------------------|------------------------------|----------------|--|-----------------------|-------------------------|
| | | Description of NC | | Corrective Action Section B | | \/ - \(\frac{16}{1} = -4\frac{1}{2} = -4 | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspecto |
| | | | | | | | | |
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| <i>j</i> | | | | | | | | |
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NOTE: Date & initial all entries

^{*} H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD



SECTION A-A

(REF)

O O $\boldsymbol{\varpi}$ \rightarrow

05.11.14 98.10.19 96.03.29 95.01.25

UPDATE ADDED

NOTES

₩ DRAWING NO. D2460 DART RT AEROSPACE LTD SHEET

05.11.14

STEP WELDMENT

ASSEMBLY

1:10

1 OF 1 SCALE

NEW

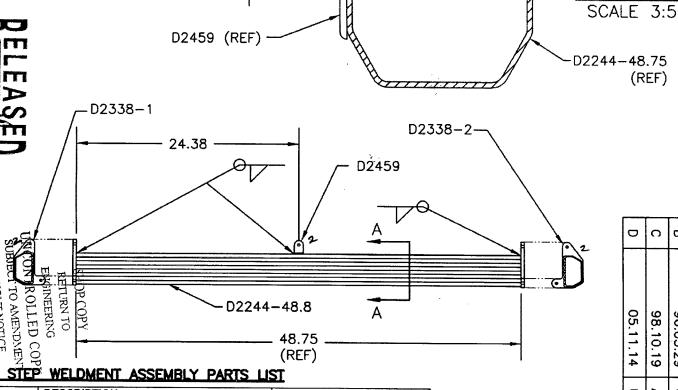
ISSUE

CHANGE END PLATES

SECTION A-A FINISHING

(TSR

A915)



0.15

| P/N | DESCRIPTION | QTY | . Lava e weekii (filozofia) |
|------------|------------------------|-----|-----------------------------|
| D2460 | STEP WELDMENT ASSEMBLY | X | |
| D2244-48.8 | EXTRUSION* | 1 | |
| D2338-1 | ENDPLATE | 1 | |
| D2338-2 | ENDPLATE | 1 | |
| D2459 | ANGLE | . 1 | |

cut per drawing

WITHOUT NOTICE WORK ORDER

Š

D2460 STEP WELDMENT ASSEMBLY NOTES

- MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID TOP SURFACE TO BOTTOM OF

RADIUS PER DART QSI 005 4.4

- ALL DIMENSIONS ARE IN INCHES 4)
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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